



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3488-4**Job Sheet 195263****Part No:** D3488-4**Job Qty:** 12 pcs**Part Name:** Blade Fitting, RH**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 5/16/19**Job Tracking No:****Due Date:** 6/20/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DSK101 REV.D / D3488 REV.C IPP REV:A 18.11.09 NEW ISSUE DD VERF:JFS**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	12 pcs		6/20/19	0.00	10.55	Doosan - 1		JBD 19/05/29
110	QC 2	12 pcs		6/20/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

Plex 5/16/19 12:44 PM Dart.lajeunesse.marie

120 HAAS 4 Axis - B4B	12 pcs	6/20/19	0.11	8.23	QC 2 - 65	JSD 19/05/19
					QC 2 - 5	
					QC 2 - 71	
					HAAS - 1 - B4B	
					HAAS - 2 - B4B	
130 QC 2	12 pcs	6/20/19	0.00	0.00	HAAS - 3 - B4B	
					HAAS - 4 - B4B	Kt 19-07-14
					QC 2 - 1	Kt 19-07-14
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
140 QC 8	12 pcs	6/20/19	0.00	0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	mm L 19/07/15
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	

					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
150	Handfinish - 1-1 Chemical-B4B	12 pcs	6/20/19	0.00 0.35	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	ST JUL 15 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
160	Powdercoat - 1 White Gl(A)-B4B	12 pcs	6/20/19	0.00 0.42	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	BK 19-7-15
					Powdercoat - 4 - B4B	
170	QC 3	12 pcs	6/20/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	AL 19-7-15
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	

Plex 5/16/19 12:44 PM Dart.lajeunesse.marie

Plex 5/16/19 12:44 PM Dart.lajeunesse.marie

				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	12 pcs	6/20/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	JUL 16 2019
				QC 21 - SA - 53	

Part Op 100 - Doosan (Doosan Lathe) 1-Turn as per Dwg DSK 101 & Folio FC492
 Descriptions: 110 - QC2 Machining-2 (QC2- Inspect parts off machine FAI/FAIB)
 120 - HAAS1-3 (HAAS CNC Vertical Machine) 1-Machine as per Folio FA627 & Dwg D3488
 130 - QC2 Machining-2 (QC2- Inspect parts off machine FAI/FAIB)
 140 - QC8 Machining-2 (QC8- Inspect parts - second check)
 150 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1)
 160 - Powdercoat1 (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____
 170 - QC3 (QC3- Inspect Part Finish)
 200 - Packaging3-1 (Identify as per dwg & Stock Location: _____ LOCATION : FP001)
 210 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6103-003	Round Billet, Aluminum	12 pcs (1 ea)	100-Doosan - 1	5157287 5182446

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	D6103-003	12	17	0

Part Specifications
Specifications could not be found.

DAS
70
9-89

Plex 5/16/19 12:44 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S185284



Part: D3488 - 4

Job No: 195263

Serial No/Batch: S185284

Revision: D/C

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K84 1K7
CANADA
TEL.: 1 813 832-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/29/19

DART AEROSPACE LTD	Work Order: 195263
Description: Blade Fitting, RH / Turning Detail for D3488-4	Part Number: D3488-4
Inspection Dwg: D3488 / DSK101 Rev: C / D	Page 2 of 2

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Milling Section						
Ø0.508	+0.006/-0.001	0.508	✓		Kt-05	vern.
0.750	+/-0.010	0.750	✓		31006	H-G
1.500	+/-0.010	1.500	✓		Kt-05	vern.
11.18	+/-0.030	11.17	✓		31006	H-G
R0.062	+/-0.010	0.0625	✓		—	R-G
0.125	+/-0.010	0.125	✓		Kt-05	vern.
0.590	+/-0.010	0.593	✓		H-G	31006
0.793	+/-0.010	0.794	✓		Kt-05	vern.
1.351	+/-0.010	1.341	✓		31006	H-G
1.317	+/-0.010	1.317	✓		Kt-02	micrometer
1.802	+/-0.010	1.802	✓		31006	H-G

Measured by: Kt	Checked by: MML	QC Inspector:
Date: 19-07-13	Date: 19/07/15	Date:

Engineering Approval: (if necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
A	19.06.14	New Issue	MG met	HA

